

Work Order ID 132145

Tuesday, April 28, 2015 11:00:41 AM

132145

Page 1

Item ID: D4182-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fitting, Quick Disconnect

Stop ***NS2***

Start Date: 4/28/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 5/8/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MFDate: 15-4-28

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4182

B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

28291

Purchase Part Number: P/N 6718K52

Supplier: MCMASTER CARR

Material release note is required.

OK 15/04/28 12

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material release note is attached

12X 15-04-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____											

Work Order ID 132145***132145***

Page 2

Tuesday, April 28, 2015 11:00:41 AM

Item ID: D4182-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fitting, Quick Disconnect
Start Date: 4/28/2015 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 5/8/2015 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120						(12)			APR 29 2015
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location	0.00							DAS 6 9-89
130									APR 29 2015
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									APR 30 2015
QC	Memo	0.00							
Quality Control									

MCS APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

Picklist Print

Tuesday, April 28, 2015 11:00:39 AM

Page 1
1

Work Order ID: 132145

132145

Parent Item: D4182-1

D4182-1

Parent Item Name: Fitting, Quick Disconnect

Start Date: 4/28/2015

Required Date: 5/8/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.10.05 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6718K52		Purchased		No		110	Each	0.0000	1	12			

6718K52

Fitting, Quick Disconnect

******2x SPD-04-29

DQA: _____ Date: _____



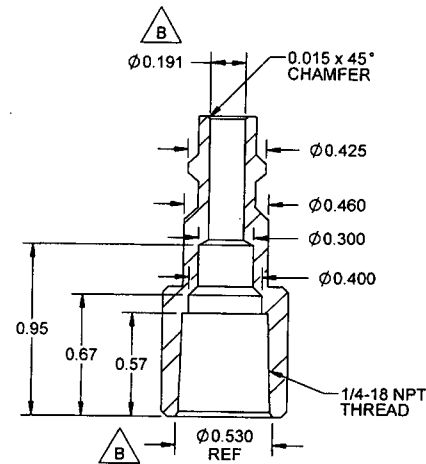
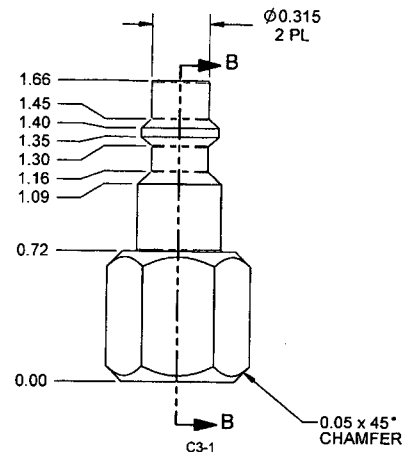
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

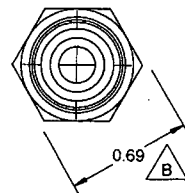
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

SPECIFICATION CONTROL DRAWING



SECTION B-B CS-1



D4182-1 FITTING, QUICK DISCONNECT

NOTES:

- 1) MATERIAL: STAINLESS STEEL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs
- 8) POSSIBLE SUPPLIER: McMASTER CARR P/N 6718K52

B	$\phi 0.191$ WAS $\phi 0.201$ (ZN D4-1); 0.57 WAS 0.45 (ZN C4-1); 0.69 WAS 0.62 (ZN B5-1)	RF	11.03.07
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.03.07		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

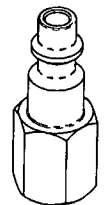
DRAWING NO. **DSC-D4182** REV. B
SHEET 1 OF 1

TITLE **FITTING** SCALE NTS

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RELEASED
2011-06-30
ND

#132145



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28291**

Purchase Order Date 4/28/2015

PO Print Date 4/28/2015

Page Number 5 of 5

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 330 995 5500

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 10

Currency USD

FOB FCA - (Free Carrier)

13 6718K52	Fitting, Quick Disconnect	4/29/2015	12.00	\$5.81	\$69.72
		Yes	Each		
		4/29/2015			

AS PER DWG D4182 REV. B
B132145

SP15-04-29.

Line Total: \$69.72

PO Total: \$746.67

24

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 4/28/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO28291

Order Placed By
Chantal Lavoie

McMaster-Carr Number
2674936-02

Page 1 of 1

04/28/2015

Line	Product	Ordered	Shipped
1	31425A22 Locking Sleeves for Removable Drill Bushing, 1/2" ID, 3/4" OD, 3/4" Length Your Part Number: 71525-10	15 Each	15
2	5259T5 Load-Center Circuit Breaker, Siemens Qp Series, Double Pole, 120/240 VAC, 15 Amps Your Part Number: 71725-45	1 Each	1
3	5644K14 Retracting Air Hose, 5/16" ID, 3/8" OD, 210 PSI, Red, 100' Long Your Part Number: 71725-45	1 Each	1
4	10095K32 Loc-Line Any-Which-Way Coolant Hose, 1/2" ID, Coolant Supply Connector, 3/8" NPT Male, Packs of 4 Your Part Number: 71500-30	1 Pack	1
5	10095K12 Loc-Line Any-Which-Way Coolant Hose, 1/2" ID, Hose Assembly with Connectors & Nozzles Your Part Number: 71500-30	1 Each	1
6	8054T17 Stranded Wire, 300V AC, 14 Gauge, 200 ft, Red Your Part Number: 71725-45	1 Each	1
8	8054T17 Stranded Wire, 300V AC, 14 Gauge, 200 ft, White Your Part Number: 71725-45	1 Each	1
9	7150K74 Thin-Wall Conduit (EMT) Fitting, Set Screw Connector, Zinc, 1/2 Trade Size Your Part Number: 71725-45	15 Each	15
10	7150K77 Thin-Wall Conduit (EMT) Fitting, Compression Coupling, Zinc, 1/2 Trade Size Your Part Number: 71725-45	15 Each	15
11	8081K21 Thin-Wall EMT Conduit Fitting, 90 Degree Set Screw Pulling Elbow, 1/2 Trade Size Your Part Number: 71725-45	4 Each	4
12	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size Your Part Number: 6718K52	12 Each	12

Shipped separately from our Chicago warehouse on 04/28

7 **8054T17** Stranded Wire, 300V AC, 14 Gauge, 200 ft, Black
1
Each

McMaster-Carr Supply Company
 200 Aurora Industrial Pkwy
 Aurora, OH 44202-8087 USA
 Phone: 330-995-5500 Fax: 330-995-9600
 E-Mail: cle.sales@mcmaster.com
 Employer Identification Number (EIN): 36-1458720

Invoice: 28784362
 Purchase Order: PO28291
 Release:
 McMaster-Carr Number: 2674936-02

ORIGINAL COMMERCIAL
INVOICE
 CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
6	8054T17 Stranded Wire, 300V AC, 14 Gauge, 200 ft, Red 71725-45 Country of Origin: United States Schedule B #: 854449 ECCN #: EAR99 NLR	1 EA	\$70.51	\$70.51
8	8054T17 Stranded Wire, 300V AC, 14 Gauge, 200 ft, White 71725-45 Country of Origin: United States Schedule B #: 854449 ECCN #: EAR99 NLR	1 EA	\$70.51	\$70.51
9	7150K74 Thin-Wall Conduit (EMT) Fitting, Set Screw Connector, Zinc, 1/2 Trade Size 71725-45 Country of Origin: United States Schedule B #: 790700 ECCN #: EAR99 NLR	15 EA	\$0.62	\$9.30
10	7150K77 Thin-Wall Conduit (EMT) Fitting, Compression Coupling, Zinc, 1/2 Trade Size 71725-45 Country of Origin: United States Schedule B #: 790700 ECCN #: EAR99 NLR	15 EA	\$1.61	\$24.15
11	8081K21 Thin-Wall EMT Conduit Fitting, 90 Degree Set Screw Pulling Elbow, 1/2 Trade Size 71725-45 Country of Origin: India Schedule B #: 790700 ECCN #: EAR99 NLR	4 EA	\$3.08	\$12.32
12	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" NPTF Female, 1/4 Coupling Size 6718K52 Country of Origin: United States Schedule B #: 848190 ECCN #: 2B999 NLR	12 EA	\$5.81	\$69.72
NOTE Tracking number(s) for this shipment: 633862306303		Sp15-04-28		